

Work Order ID 73298

Wednesday, August 31, 2011 10:45:33 AM

Page 1

Item ID: D3413-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Ring

Start Date: 9/1/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3413

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3413

Dwg Rev: AProg Rev: A

2-Deburr if necessary

304 .750 X 4

B11-9-7



E. B. 10/09/12

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-9-7

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S. 10/09/13

counts
470

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:

Item Name: Ring

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Start Date: 9/1/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 20.00



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Run Start



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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1

ES 11/09/12 (20)

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

Serial 3

count (20)

150

0.00



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

0.00

Powder Coating

START TIME: *2:30* OVEN TEMPERATURE: _____
FINISH TIME: *3:00*

400°F

3:00

20x1 M-11/09/14

M/18439

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Page 3

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Setup Start



Revision ID:

Stop



Item Name: Ring

Start Date: 9/1/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

20 BL 11-9-15

170

Identify as per dwg & Stock Location: ST 468

0.00



Packaging

Memo

0.00

Packaging

SP SP (20x) 11-09-15

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/15

UMF 11-09-15

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Picklist Print

Wednesday, August 31, 2011 10:45:29 AM

Page 1

Work Order ID: 73298



Parent Item: D3413-1



Parent Item Name: Ring

Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 05.09.13 New issue KJ/JLM
IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000 		Purchased	No			100	f	18.5000	0.25	5.263158			
304 BAR .250 x 4.00												B11-9-7	

Location

Loc Qty

Loc Code

MAT009

18.5

118182

18.5

118182



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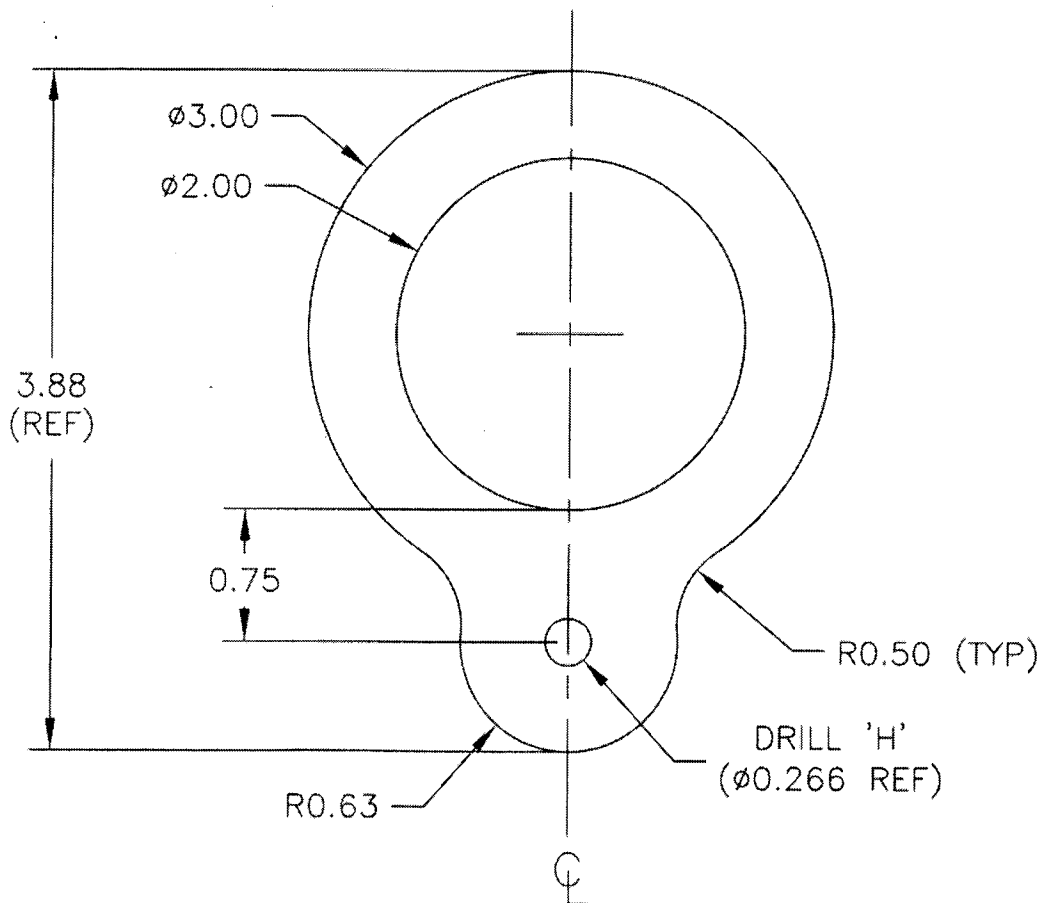
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DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

RELEASED
05-09-06 *[Signature]*



D3413-1 RING

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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